

Date: Monday, 5/15/2006 11:11:55 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: RING
Job Number	: 27110		
Estimate Number	: 10608		
P.O. Number	: N/A	Part Number	: D2655
This Issue	: 5/15/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2655 REV B
First Issue	: 5/15/2006	Project Number	: N/A
Previous Run	: 25145	Drawing Revision	: B
		Material	: N/A
Written By	:	Due Date	: 5/30/2006
Checked & Approved By	:	Qty:	40 Um: Each
Comment	: Est. D 00.05.22 Removed P/O for powder coat EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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## Comment: PURCHASING

Issue P/O: 1263

Laser Cut per D2655

Material release note required

206105116 (40)

2.0	D2655F	Ring
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)  
 Ring

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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## Comment: PACKAGING RESOURCE #1

Recieve &amp; Inspect for Transit Damage

Ensure Material Release Note is attached

206105116 (40)

4.0	QC6	DIMENSIONAL CHECK
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## Comment: DIMENSIONAL CHECK

206105116 (40)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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## Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1-Tumble - .030 Radius

2-Deburr any rough edges after tumbling

NA 206105116 (40)  
 M.F. 06/05/31 (40)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_

NOTE: Date & initial all entries

NCR: Yes ☒ No ☐ DQA:  Date: 06/06/09

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date:  
User:

Monday, 5/15/2006 11:11:55 AM  
Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RING

Job Number: 27110

Part Number: D2655

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Job 06-06-05*

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING  
Powder Coat per QSI 005 4.3.5.1

*DC 06/06/08*

*(40)*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*PC 6/6/9 (40)*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST140*

*PC 6/6/9 (40)*

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL  
Inspection Level 21

*DC 06/06/09 (40)*

Job Completion



*W 06-06-09*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

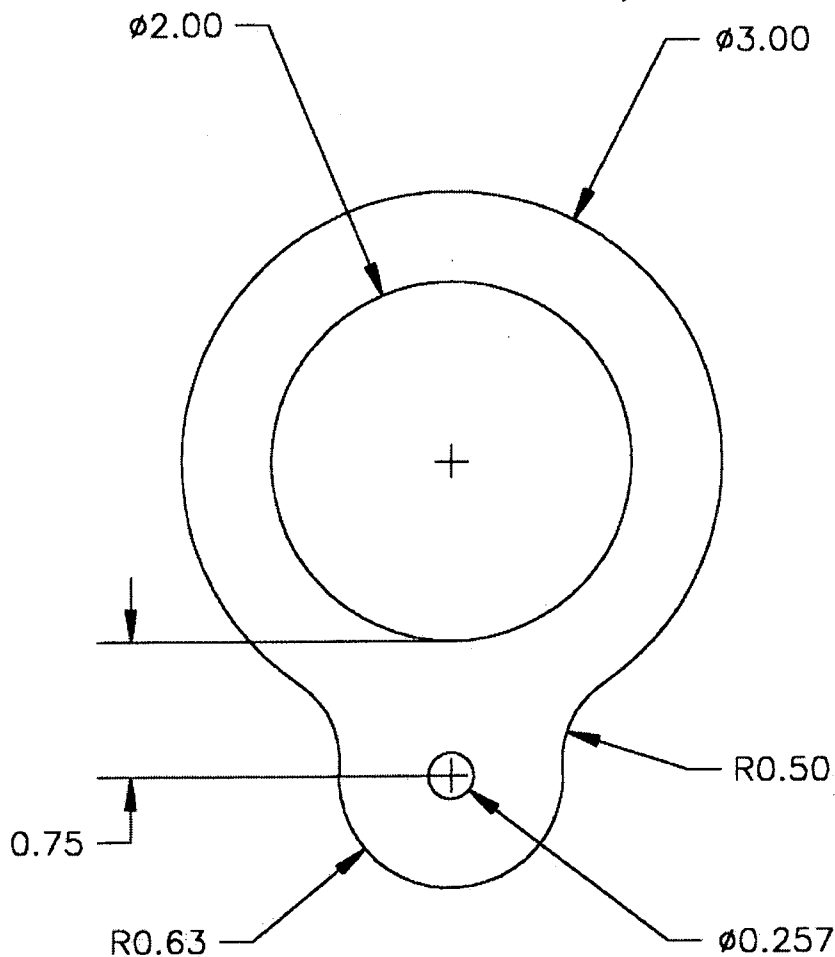
NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2655	REV. B SHEET 1 OF 1
DATE 97:07:07		TITLE RING	SCALE 1:1
A	97:03:25	NEW ISSUE	
B	97:07:07	ADD ASTM A36 TO MAT. SPEC.	

RELEASED  
97/07/11 DS



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 27110

NOTE: DEBURR ALL SHARP EDGES  
MATERIAL: AISI 1018/1020/1025 OR ASTM A36 0.250 THICK  
FINISH: POWDER COAT PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**GERDAU AMERISTEEL**

CAMBRIDGE STEEL MILL  
160 ORION PLACE  
CAMBRIDGE ON N1T 1R9 CAN  
(519) 740-2488

## Chemical and Physical Test Report

MADE IN CANADA

N-037186

SHIP TO VEDDER TRANSPORT C/O WILKINSON STEEL AND METALS 586 RIVERSIDE ROAD ABBOTSFORD, BC	INVOICE TO WILKINSON STEEL & METALS VAN PREMETALCO INC 888 SOUTHEAST MARINE DR. VANCOUVER, BC V5X 2V3	SHIP DATE 01/12/06  CUST. ACCOUNT NO 60073890
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SHAPE + SIZE	GRADE		SPECIFICATION														SALES ORDER	CUST P.O. NUMBER																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																
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Mechanical Test: Yield 50258 PSI, 346.52 MPa Tensile: 74435 PSI, 513.21 MPa %E: 27.0/8in, 27.0/200MM Red R 26.7 : 1

Mechanical Test: Yield 49865 PSI, 342.43 MPa Tensile: 74737 PSI, 515.29 MPa %E: 27.0/8in, 27.0/200MM Red R 26.7 : 1

Mechanical Test: Yield 49665 PSI, 342.43 MPa    Tensile 14737 PSI, 515.29 MPa    A51: 27.00%, A51.0000000    Shock: 2000 FT-LB																	SALES ORDER		CUST P.O. NUMBER	
SHAPE + SIZE		GRADE		SPECIFICATION													511357-03		P51121MV001	
A2 X 2 X 1/4		44W		CSA-G40.21-300W-98(44W); ASTM A36/A36M-04																
HEAT ID.		C	Mn	P	S	Si	Cu	Ni	Cr	Mo	V	Nb	B	Sn	Al	Zr	C Eqv			
N545180		.15	.63	.011	.034	.18	.27	.09	.16	.043	.004	.001	.0000	.019	.001	.002	.325			

Mechanical Test: Yield 48109 PSI, 331.7 MPa Tensile: 70847 PSI, 488.47 MPa %E: 28.5/8in, 28.5/200MM Red R 26.7 : 1

Mechanical Test: Yield 48088 PSI, 331.56 MPa Tensile: 71075 PSI, 490.04 MPa %E: 28.0/8in, 28.0/200MM Red R 26.7 : 1

Mechanical Test		Yield 48008 PSI, 331.55 MPa		Tensile 71075 PSI, 490.04 MPa		Elong. 20.00mm, 20.00mm		Yield to Break 20.00mm		SALES ORDER		CUST P.O. NUMBER																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																			
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Mechanical Test: Yield 50597 PSI, 348.65 MPa Tensile: 73436 PSI, 506.32 MPa %E: 27.0/8in, 27.0/200MM Red R 26.7 : 1

Mechanical Test: Yield 50554 PSI, 348.56 MPa Tensile: 73611 PSI, 507.53 MPa %E: 27.0/8in, 27.0/200MM Red R 26.7 : 1

This material, including the billets, was produced and manufactured in Canada.

A.J. Turner

Quality Assurance Manager

Mill Group

THE ABOVE FIGURES ARE CERTIFIED EXTRACTS FROM THE ORIGINAL CHEMICAL AND PHYSICAL TEST RECORDS  
AS CONTAINED IN THE PERMANENT RECORDS OF COMPANY.

Mgt. Metallg. Svcs.

CAMBRIDGE STEEL MILL

P51013PC002

## MILL TEST CERTIFICATE

872

ORIGINAL



YIEH MAU CORP.

INVOICE NO. :

YIEH MAU CORP.

COMMODITY :

F05MA29

PRIME COLD ROLLED STAINLESS STEEL SHEET

SPECIFICATION :

AISI 304

CUSTOMER :

OLBERT METAL SALES LIMITED

16GA 304 SS

工廠:高雄路竹鄉廣安路345號  
245, SHUN AN RD. LU CHU HSIANG  
KAOHSIUNG TAIWAN R.O.C.  
TEL:(07)8912385 FAX:(07)8973006  
CERTIFICATE NO: F05MA29  
DATE OF ISSUE: 11/30/2005

SIZE	NO.	Weight (N.W.)		Heat No.	ID NO.	Physical Properties Tensile Test CL=50 mm					Chemical Composition (%)							
		Y.S. (N/mm <sup>2</sup> )	T.S. (N/mm <sup>2</sup> )			E.L. (%)	HRB	HV	C x100	Si x100	Mn x100	P x1000	S x1000	Ni x100	Cr x100	N x100		
																	KGS	LBS
AISI 304 NO.4 (FLAT ON MAIN SIDE WITH BACK PASS)																		
16GA / 48" X 96"	1	1,476	3,264	YU236038	4AS16493A-32	297	659	51	79	149	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 96"	1	1,479	3,261	YU234718	4AS16505B-21	310	690	50	81	158	4.1	55	124	31	7	804	1816	3.1
16GA / 48" X 96"	1	1,479	3,261	YU234718	4AS16505B-22	316	690	50	81	158	4.1	55	124	31	7	804	1816	3.1
16GA / 48" X 120"	1	1,530	3,373	YU236038	4AS16494A-11	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	1	1,535	3,384	YU236038	4AS16494A-12	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	1	1,539	3,391	YU236038	4AS16494A-13	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	1	1,540	3,395	YU236038	4AS16494A-14	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	1	1,541	3,397	YU236038	4AS16494A-15	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	1	727	1,603	YU236038	4AS16494A-16	315	675	51	80	155	4.3	48	105	32	12	805	1818	2.9
16GA / 48" X 120"	1	1,633	3,600	YU234718	4AS16505B-23	316	690	50	81	158	4.1	55	124	31	7	804	1816	3.1
16GA / 48" X 144"	1	1,838	2,950	YU236038	4AS16493A-31	297	659	51	79	149	4.3	48	105	32	12	805	1818	2.9
12GA / 48" X COIL	1	3,308	7,293	YU129569	4S18207A-11	310	626	52	83	163	4.5	46	127	31	7	816	1817	2.8
TOTAL:		12	19,024	41,942														
Remarks:		NO MERCURY CONTAMINATION																
		Heat test good for all Heat NO.																

YIEH MAU CORP.

*Lin Kun Hing*  
Manager of Quality Assurance Section

P.03

505 755 1320

OLBERT METAL SALES

JAN-10-2006 16:59

F05295MA29-1 T M INDUSTRIAL (P51013PC002, YU236038)

